

Amendment to the Specification

Please amend paragraph [0018] of the specification as shown:

[0018] As shown in FIG. 1, the duct member 20 may be produced from a flat blank of material which is rolled such that opposed seams of the blank slightly overlap and are coupled to one another to form the tubular blank workpiece configuration 30. Coupling at the overlapping seams may be provided in any suitable manner, such as by riveting 32 or the like. As an example, the tubular configuration 30 of the formed blank of material may provide a starting work piece 30 which may then be operated on by the apparatus and methods of the invention. The work piece 30 is designed to have a predetermined configuration and dimensional characteristics for use in the apparatus and methods of the invention, but any suitable particular dimensional characteristics of the work piece can be accommodated. The apparatus and methods of the invention will take the work piece as shown in FIG. 1 and produce adjustable seams or beads 23, 25, and 27 in the work piece as depicted in FIGS. 2-8 to form the duct member ~~10~~ 20 in the final preferred form as shown in FIG. 9. In contrast, existing automatic elbow machines will produce a final article X as shown in FIG. 10 and requiring manual rotation A, B, C of each gore by an operator to form a 90 degree elbow.

Please amend paragraph [0021] of the specification as shown:

[0021] The apparatus 50 also preferably includes a control system generally designated 110, which may be any suitable system such as a microprocessor or PLC based system, to selectively perform the various operations and steps to produce the duct member 20 according to the methods of the invention. Preferably, control system 110 can be designed to automatically perform various operations in a manufacturing sequence to produce a particular type of duct member 20. Each different type of duct member will effectively have a process sequence recipe that can be simply recalled using the control system 110, with subsequent automated performance of each step in the manufacture of the duct member ~~10~~20. In this way, an unskilled

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operator can simply recall a particular recipe for the type of duct member to be produced, alleviating the necessity for a skilled operator and simplifying the manufacturing process.